












Date: Thursday, 17/08/2006 3:20:55 PM
User: Linda Lacelle

Process Sheet

| | | | |
|---|------------------------------|---|--|
| Customer : CU-DAR001 Dart Helicopters Services | | Drawing Name : 206L/L/L3/L4 HIGH GEAR SKID | |
| Job Number : 28220 | | | |
| Estimate Number : 10525 | | | |
| P.O. Number : <i>N/A</i> | | Part Number : D206642411 | |
| This Issue : 17/08/2006 S.O. No. : <i>N/A</i> | | Drawing Number : N/A | |
| Prsht Rev. : NC | | Project Number : N/A | |
| First Issue : <i>N/A</i> Type : LANDING GEAR | | Drawing Revision : N/A | |
| Previous Run : 27097 | | Material : <i>N/A</i> | |
| Written By : _____ | | Due Date : 15/09/2006 Qty: 1 Um: Each | |
| Checked & Approved By : _____ | | | |
| Comment : Est Rev:K 05.10.10 Revised picklist per CHG004 KJ/CP/JLM | | | |
| Additional Product | | | |
| Job Number:  | | | |
| Seq. #: | Machine Or Operation: | Description : | |
| 1.0 | DC | DOCUMENT CONTROL | |
|  | |  | |
| Comment: DOCUMENT CONTROL Photocopy bluefile and create labels per PPP D206-642-411 CHG004 <i>RS 06.09.06</i> (1) | | | |
| 2.0 | 28220A | 206 L HIGH GEAR SKIDTUBE | |
|  | |  | |
| Comment: Sub-Component 206 L HIGH GEAR SKIDTUBE | | | |
| 3.0 | PACKAGING 1 | PACKAGING RESOURCE #1 | |
|  | |  | |
| Comment: PACKAGING RESOURCE #1 Pick Packing Kit <i>204/13</i> (1) | | | |
| 4.0 | D2652 | Bushings | |
|  | |  | |
| Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch ✓ 24 D2652 Bushing <i>B27832</i> 1 D206-642-441(REF) <i>B28220A</i> | | | |
| 5.0 | D2655 | Ring | |
|  | |  | |
| Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch ✓ 1 D2655 Tow Ring <i>B27110</i> | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L/L3/L4 HIGH GEAR SKID

Job Number: 28220

Part Number: D206642411

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2659

Lug Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

✓ 2 D2659 Lug Assembly B28254

7.0

D2712

Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

✓ 10 D2712 Set Screw B28746

8.0

D29321

206 Saddle Left side



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

✓ 1 D2932-1 Saddle B28260

9.0

D29331

206 Saddle Left



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

✓ 1 D2933-1 Saddle B28669

10.0

D2934

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

✓ 2 D2934 Saddle Spacer B28264

11.0

D2935

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

✓ 2 D2935 Saddle Spacer B28265

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
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Drawing Name: 206L/L/L3/L4 HIGH GEAR SKID

Job Number: 28220

Part Number: D206642411

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D29381

206 Saddle Left side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

✓ 1 D2938-1

Saddle

B27117

13.0

D29391

206 Saddle Left side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

✓ 1 D2939-1

Saddle

B27207

14.0

D2968043

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

✓ 1 D2968-043

Tow Ring

B28268

9 sort 1, 8 sort 2

15.0

AN337A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

✓ 4 AN3-37A

Bolt

M14478

16.0

AN341A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

✓ 8 AN3-41A

Bolt

M102171

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Date: Thursday, 17/08/2006 3:20:56 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L/L3/L4 HIGH GEAR SKID

Job Number: 28220

Part Number: D206642411

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|------|-------|------|
| 17.0 | AN45A | Bolt |
|------|-------|------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

✓ 1 AN4-5A

Bolt M100857

| | | |
|------|-------|------|
| 18.0 | AN46A | Bolt |
|------|-------|------|



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

✓ 12 AN4-6A

Bolt M101418

| | | |
|------|--------|------|
| 19.0 | AN511A | Bolt |
|------|--------|------|



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

9 8 AN5-11A

Bolt M101291 M102328

| | | |
|------|--------|------|
| 20.0 | AN512A | Bolt |
|------|--------|------|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

✓ 4 AN5-12A

Bolt M101069-

| | | |
|------|--------|------|
| 21.0 | AN513A | Bolt |
|------|--------|------|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

✓ 4 AN5-13A

Bolt M15928-

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L/L3/L4 HIGH GEAR SKID

Job Number: 28220

Part Number: D206642411

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

AN960JD10

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

✓ 12 AN960JD10

Washer M100743-

23.0

AN960JD1016

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Qty Part Number

Description Batch

✓ 1 AN960JD1016

Washer M5519-

24.0

AN960JD416

Washer



Comment: Qty.: 25.0000 Each(s)/Unit Total: 25.0000 Each(s)

Qty Part Number

Description Batch

✓ 25 AN960JD416

Washer M102335-

25.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Qty Part Number

Description Batch

✓ 8 AN960JD516

Washer M132328-

26.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Qty Part Number

Description Batch

✓ 1 AN970-4

Washer M10051-

27.0

MS21042L3

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Qty Part Number

Description Batch

✓ 12 MS21042L3

Nut (or -3) M101390-

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *P* Date: 04/11/01
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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Date: Thursday, 17/08/2006 3:20:56 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L/L3/L4 HIGH GEAR SKID

Job Number: 28220

Part Number: D206642411

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

MS21042L4

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Qty Part Number

Description Batch

✓ 13 MS21042L4

Nut (or -4) M19099

Rec'd 10/31 (1)

29.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

OB 06/10/31 (1)

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-411

Location:

PPP Rev: D

PB 06/10/31 (1)

31.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Q 06/11/01 (1)

Job Completion



C Lacelle

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Date: Thursday, 17/08/2006 3:21:48 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206 L HIGH GEAR SKIDTUBE
 Job Number : 28220A
 Estimate Number : 10522
 P.O. Number : N/A Part Number : D206642441
 This Issue : 17/08/2006 S.O. No. : N/A Drawing Number : D2650 REV E
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : E
 Previous Run : 27101A Material : N/A
 Due Date : 15/09/2006 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev. H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-441 CHG002

N/A.

2.0 D2620 Bent 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2620 Bent Tube 3" OD

B23457

DP 6-9-18

3.0 D2647 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2647 Fwd Cap

B24842

BE

6-9-19

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R Aluminum Rod m10/655 BE 6-9-19

4-Grind weld flush to cap on top surface only. Pm 6-9-20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Date: Thursday, 17/08/2006 3:21:48 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 28220A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

5-Cut aft end 138.60" from front of tube *Pm 06-9-201*

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312". *DP 6-9-28*

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297". *Pm 06-9-280*

8-Open using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail *DP 6-9-28*

10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650

11-Deburr and Blow out all chips form inside the tube *Pm 06-9-280*

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Pm 06-9-290



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

6.0

D26547

206 L Beam (Web)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2654-7

Web

B28238

Pm 06-9-290

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail (without cutting fluid) *Pm 06-9-290*

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid) *Pm 06-9-290*

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer. *Pm 06-9-290*

4-Bond D2654-7 web in place as per QSI 015Ensure holes line upAllow 12 Hrs. cure time before cutting

Start Date: *06-9-29* Time: *1015*

Finish Date: *06-09-30* Time: *12:00*

A/R Sikaflex-291

M 101953

Sikaflex expiry date: *06-10-21*

Pm 06-9-290

| W/O: | | WORK ORDER CHANGES | | | | | |
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 28220A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE

06-10-03

9.0

D2649

Crossbolt Spacer



Comment: Qty.: 23.0000 Each(s)/Unit Total : 23.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

23 D2649

Crossbolt spacer

328250

BE

06-10-03

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R Aluminum Rod M 101010 BE 06-10-03

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube pm 06-10-40

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650 Debur pm 06-10-41

11.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2680-041

Nut Plate

B24203

pm 06-10-41

12.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 CCR264SS3-3

Rivets

M101938

pm 06-10-41 (2)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Job Number: 28220A

Part Number: D206642441

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
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| | | |
|------|----------|-------|
| 13.0 | M7885343 | Rivet |
|------|----------|-------|



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 M7885/3-4-3

Rivets

M19099

pm' 06-10-4 (2)

| | | |
|------|-----------------|----------------------------|
| 14.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|------|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

pm' 06-10-4 (1)

| | | |
|------|-------|-----------------|
| 15.0 | QC5/9 | WELD INSPECTION |
|------|-------|-----------------|



Comment: WELD INSPECTION

Feb 10 10 (1)

1/24 06/10/05

| | | |
|------|----------------|----------------|
| 16.0 | POWDER COATING | POWDER COATING |
|------|----------------|----------------|



Comment: POWDER COATING

Powder Coat White (Ref. 4.3.5.1) as per QSI 005 4.3

Make sure Nut Plate Thread protected use paint screw

yl 06/10/24 x1

| | | |
|------|-----|---|
| 17.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION |
|------|-----|---|



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

a.m 06/10/25 (1)

| | | |
|------|--------|---------|
| 18.0 | D26483 | Wearpad |
|------|--------|---------|



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number

Description Batch

6 56 D2648-3

Wearpad B27169

| | | |
|------|---------|-----------|
| 19.0 | D265615 | Wearplate |
|------|---------|-----------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-15

Wearshoe

B24845

a.m 06/10/25 (1)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Thursday, 17/08/2006 3:21:48 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 28220A

Part Number: D206642441

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|------|---------|-----------|
| 20.0 | D265623 | Wearplate |
|------|---------|-----------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-23

Wearshoe B 24846

| | | |
|------|---------|-----------|
| 21.0 | D265637 | Wearplate |
|------|---------|-----------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-37

Wearshoe B 23558

| | | |
|------|--------|--|
| 22.0 | D34291 | |
|------|--------|--|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3429-1

Wearpad B 24417

| | | |
|------|-------------|--------|
| 23.0 | ALS41032130 | Insert |
|------|-------------|--------|



Comment: Qty.: 60.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 ALS4-1032-130

Inserts 18990

or (see QSI 017)

| | | |
|------|------------|--------|
| 24.0 | AN960JD10L | Washer |
|------|------------|--------|



Comment: Qty.: 60.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 AN960JD10L

Washer m 100233

a.m 06/11/25 (1)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Thursday, 17/08/2006 3:21:49 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH G

Job Number: 28220A

Part Number: D20664

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

MS27039108

Screw



Comment: Qty.: 60.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 MS27039-1-08

Screw M100354

26.0

D26511

Plug



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

Qty Part Number

Description Batch

22 D2651-1

Plugs 10x B28400

12x 28251

27.0

D26513

O-Ring



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

Qty Part Number

Description Batch

22 D2651-3

O-Rings B25866

28.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 AN960JD416

Washer M11151

29.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 MS27039-4-06

Screw M6874

2-11 06/10/25

Approval
QC Inspector
Approval
Chief Eng /
Prod Mgr

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|------|-------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Unit | Price |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 17/08/2006 3:21:49 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 28220A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2646

Aft Cap

628041

31.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN960JD10L

Washer

M100233

32.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 MS27039-1-08

Screw

M100854

33.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291

M10207

Sikaflex expiry date:

02/07

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R Sikaflex-291

M10207

Sikaflex expiry date:

02/07

6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4

Batch: 102048

a.m 06/10/26 ①

FC 06 10 26 ①

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DB Date: 06/11/07
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 17/08/2006 3:21:49 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 28220A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

Handwritten: 1022 (1)

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Handwritten: N/A

36.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Handwritten: D 06/11/01

Job Completion



Handwritten: C 206/11/01

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

NO. 15

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliott
Joint Welding Procedure TIG
Part number and Job number A286642441 / A28224 A

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS TIG
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

| | Position | Vertical | Down <input type="checkbox"/> | Up <input type="checkbox"/> |
|--------------|-----------------------------|-----------------------------|-------------------------------|-----------------------------|
| Sheet Groove | 1G <input type="checkbox"/> | 2G <input type="checkbox"/> | 3G <input type="checkbox"/> | 4G <input type="checkbox"/> |
| Tube Groove | 1G <input type="checkbox"/> | 2G <input type="checkbox"/> | 5G <input type="checkbox"/> | 6G <input type="checkbox"/> |
| Sheet Fillet | 1F <input type="checkbox"/> | 2F <input type="checkbox"/> | 3F <input type="checkbox"/> | 4F <input type="checkbox"/> |
| Tube Fillet | 1F <input type="checkbox"/> | 2F <input type="checkbox"/> | 4F <input type="checkbox"/> | 5F <input type="checkbox"/> |

Crossbolt Spacer Welded into _____ Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐

Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/10/02 Qualifier Paul Smith